

SPLIT

Dart Aerospace Ltd.

Date:

Friday, 21/12/2007 11:33:15 AM

Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WHEEL ASSEMBLY

Job Number : 36529 -1

Estimate Number : 12100

P.O. Number :

Part Number : D3397041

This Issue : 21/12/2007 S.O. No. :

Drawing Number : D3397 REV.A

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : PURCHASED PARTS

Drawing Revision : A

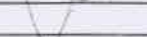
Previous Run : 34623

Material :

Written By : 

Due Date : 28/12/2007

Qty:  Um: Ea

Checked & Approved By : 

Comment : est rev. A new issue EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D3397041

wheel ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
wheel ass'y

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING
Issue P/O: 5338

Order Part #4997T28 from McMaster-Carr as per DwgD3397

Ensure Certificate of Conformity is attached

CL07/12/21

(2)

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/12/27 54 (2)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure certification comply to Dwg D3397

data 08/01/02 (2)

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing.

2-Ship retainers to machining

08/01/03 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 36529

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
1-Turn as per Dwg D3397

2-Deburr
IDENTIFY AS D3397-3

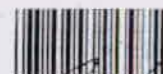
[Handwritten signature]

08 01 04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 01 04

8.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total: 12.0000 (s)

Pick:

Qty	Part number	Description	batch
1	D3397-5	sleeve	B36598

B36598

08.12.04

9.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	HK2820	bearing	M105715

M105715

08.12.04

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

08.12.04

(X7)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.04

(X7)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST471*

08/12/05 (X7)

day, 21/12/2007 11:33:15 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 36529

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/12/05 *[Signature]*

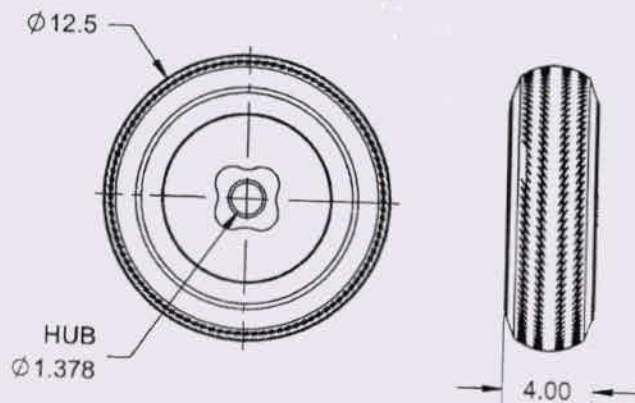
Job Completion



u 08.12.05



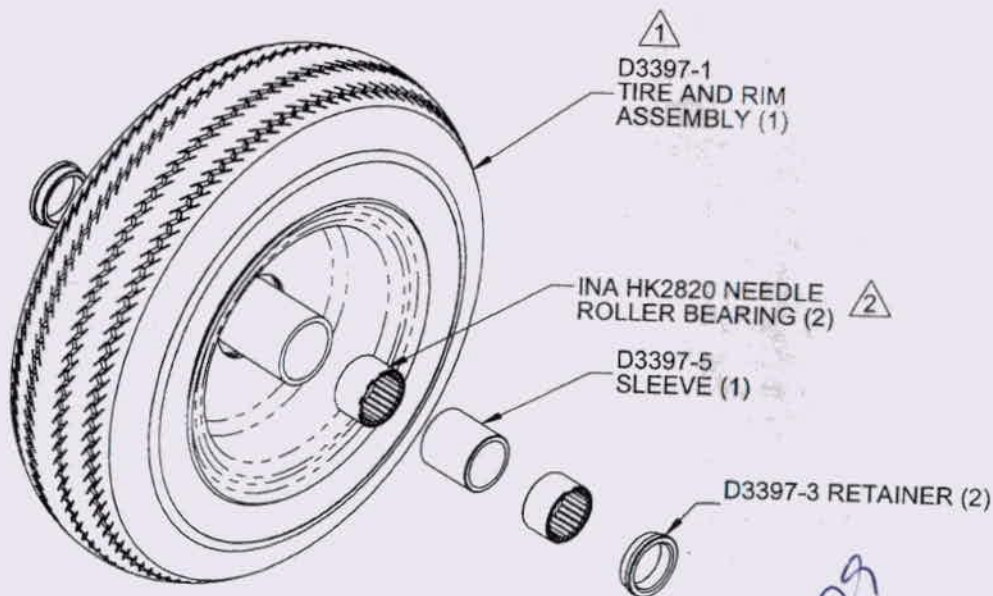
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3397	REV SHEET 1 (
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SC.
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: $\varnothing 12.4 \times 4.1$ RIM: $\varnothing 6.0 \times 4.0$	445 LBS	50 PSI*

1 D3397-1 TIRE AND RIM ASS'Y

RELEASED
06/03/07



D3397-041 WHEEL ASS'Y

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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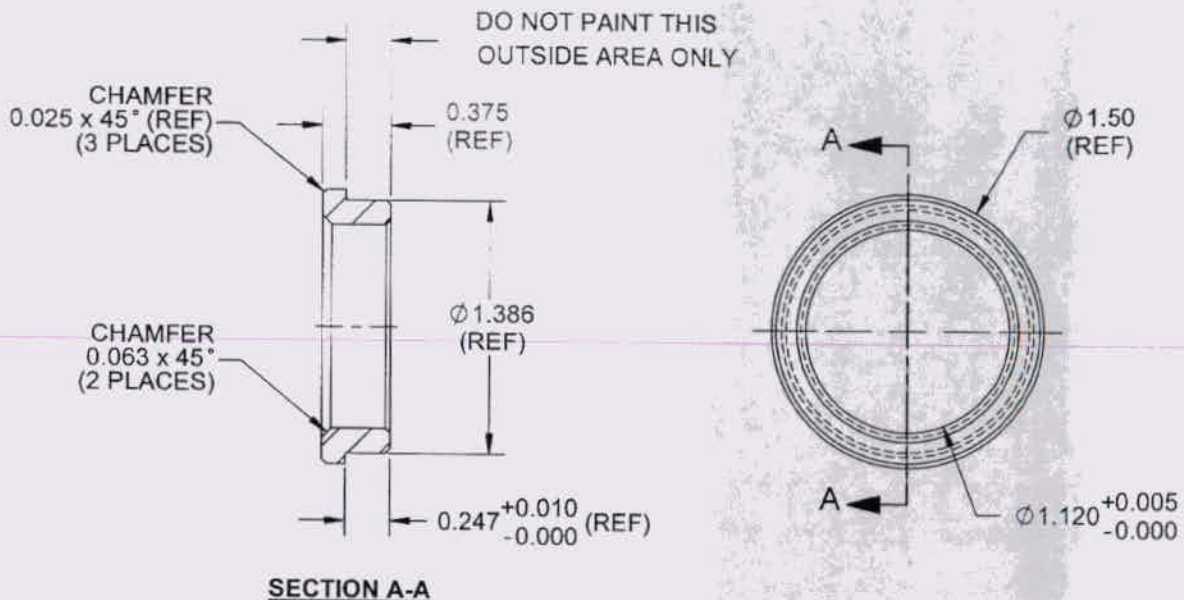
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DART

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CHECKED 3	APPROVED MC	DRAWING NO. D3397	REV SHEET 2 OF 2
DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCA

RELEASED
06/23/09

SPECIFICATION CONTROL DRAWING



D3397-3 RETAINER

NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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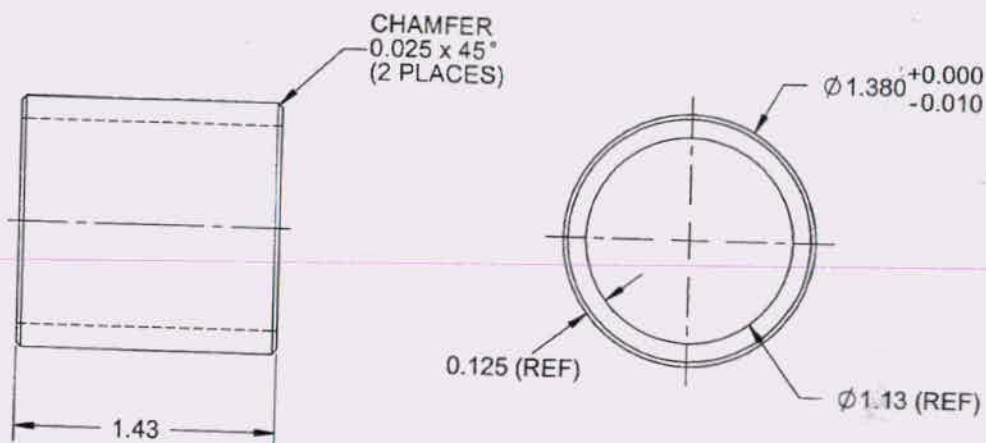
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DATE 05.02.10	TITLE WHEEL ASSEMBLY		SC

RELEASED
06/05/09

[Signature]



D3397-5 SLEEVE

Mo 36529

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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McMASTER-CARR

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 OH 44202-8087
 955-5500
 sales@mcmaster.com

Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Purchase Order
5338

McMaster-Carr Number
4491063-11

4997T28	Description	Ordered	Shipped
	Pneumatic Wheel with Tyre Piece Rim. 12.4" x 3.6", Center Hub, " Axle, Roller Bearing, 440 cap	12 Each	12
8 - 97 - 40	91-24 T28	12EA	

9/12/27
 GB

OW2



EXP

99 lbs
 1 line

